

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024561**Date Inspected:** 03-May-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Changxing Island **Location:** Shanghai, China**CWI Name:** Li Ying**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Vikram Singh was present during the times noted above for observations relative to the work being performed at ZPMC.

WELDING

TA-Yard

This QA Inspector randomly observed the following work in progress:

Shielded Metal Arc Welding (SMAW)

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as SEG3020*-013 located on deck plate to edge plate of the OBG Segment 14W. The welder is identified as 037478. ZPMC Quality Control (QC) is identified as Mr. An Qing Xiang. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G (4F)-FCM-Repair and B-WR20776.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as SEG3020AH-003 located on side plate to edge plate of the OBG Segment 14W. The welder is identified as 037932. ZPMC Quality Control (QC) is identified as Mr. An Qing Xiang. The welding variables recorded by QC appeared to comply with WPS-B-P-2212-Tc-U4b-FCM-1.

WELDING INSPECTION REPORT

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This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as SEG3020AQ-25 located on anchor plate to edge plate of the OBG Segment 14W. The welder is identified as 045246. ZPMC Quality Control (QC) is identified as Mr. An Qing Xiang. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G (4F)-FCM-Repair and B-CWR2923 Revision-1.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as SEG3020L-013 located on anchor plate of the OBG Segment 14W. The welder is identified as 037748. ZPMC Quality Control (QC) is identified as Mr. An Qing Xiang. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

Flux Cored Arc Welding (FCAW)

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as SEG3020L-014 located on deck panel diaphragm to deck panel diaphragm of the OBG Segment 14W. The welder is identified as 067949. ZPMC Quality Control (QC) is identified as Mr. An Qing Xiang. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as SEG3020D-038 located on deck panel diaphragm to floor beam flange of the OBG Segment 14W. The welder is identified as 067949. ZPMC Quality Control (QC) is identified as Mr. An Qing Xiang. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB.

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as SA3127-001-009 located on I-Rib connection plate of the OBG Segment 13CW. The welder is identified as 045143. ZPMC Quality Control (QC) is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with WPS-B-T-2231-ESAB.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey-15000026784, who represents the Office of Structural Materials for your project.

Inspected By:	Singh,Vikram	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
